

Date: Friday, 20/02/2009 10:52:02 AM
User: Jean-Luc Menard

Process Sheet

Dart Aerospace Ltd.

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 45926
Estimate Number : 12673
P.O. Number :
This Issue : 20/02/2009 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : MACHINED PARTS
Previous Run : 31861
Written By : JLM 09-02-20
Checked & Approved By :
Comment : Est Rev:A New Issue 07-01-29 JLM

Drawing Name : ADAPTER
Part Number : D35731
Drawing Number : D3573 REV.A
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 27/02/2009 Qty: 8 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0625X02500 6061-T6 Bar .625 x 2.50



Scrap 2"



Scrap 4"

Comment: Qty.: 0.3066 f(s)/Unit Total: 2.4528 f(s)
6061-T6 Bar .50" x 2.5"
Batch: 110396 110396

88 09/02/22

2.0 BAND SAW BAND SAW



PTO



Comment: BAND SAW
Cut blank 3.500" long

88 09/02/22

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA672 and Dwg D3573

J.F. 09/02/23

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/02/23

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

RQ 09/02/23

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1




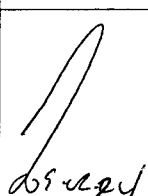



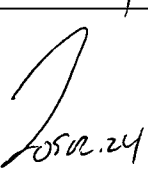


Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

OK 09-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3573-1 PAR #: N/A Fault Category: Prod/Eng coordination NCR: (Yes) No DQA: D Date: 08/02/25
412-702-105 other
Resolution: USE - AS-IS Disposition: USE - AS-IS QA: N/C Closed: D Date: 09/02/25

NCR: <u>45926</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/22	2.0.	<p>cut wrong material 8 parts are affected.</p> <p>R.C. ERROR on work/order</p> <p>Said cut 1/2 inch x 2 1/2 but the job required 5/8 x 2 1/2.</p>		<p>will pass the blank job # 5573-3 w/o 45928.</p> <p>Cut good material after.</p>	<p>SF</p> <p>09/02/22</p>			
				<p>Fix typo on EST.</p>	<p>09-02-22</p>			

NOTE: Date & initial all entries

Date: Friday, 20/02/2009 10:52:03 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 45926

Part Number: D35731

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M109648



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 8:40am

OVEN TEMPERATURE: 320°C

FINISH TIME: 9:10am

SW 08-02-24 (X5)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SR 09-02-24 (X8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

88 09/02/24 (X8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/24 (X)

Job Completion



MF 09-02-24

DART AEROSPACE LTD		Work Order:	45926
Description: Adapter		Part Number:	D3573-1
Inspection Dwg: D3573	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

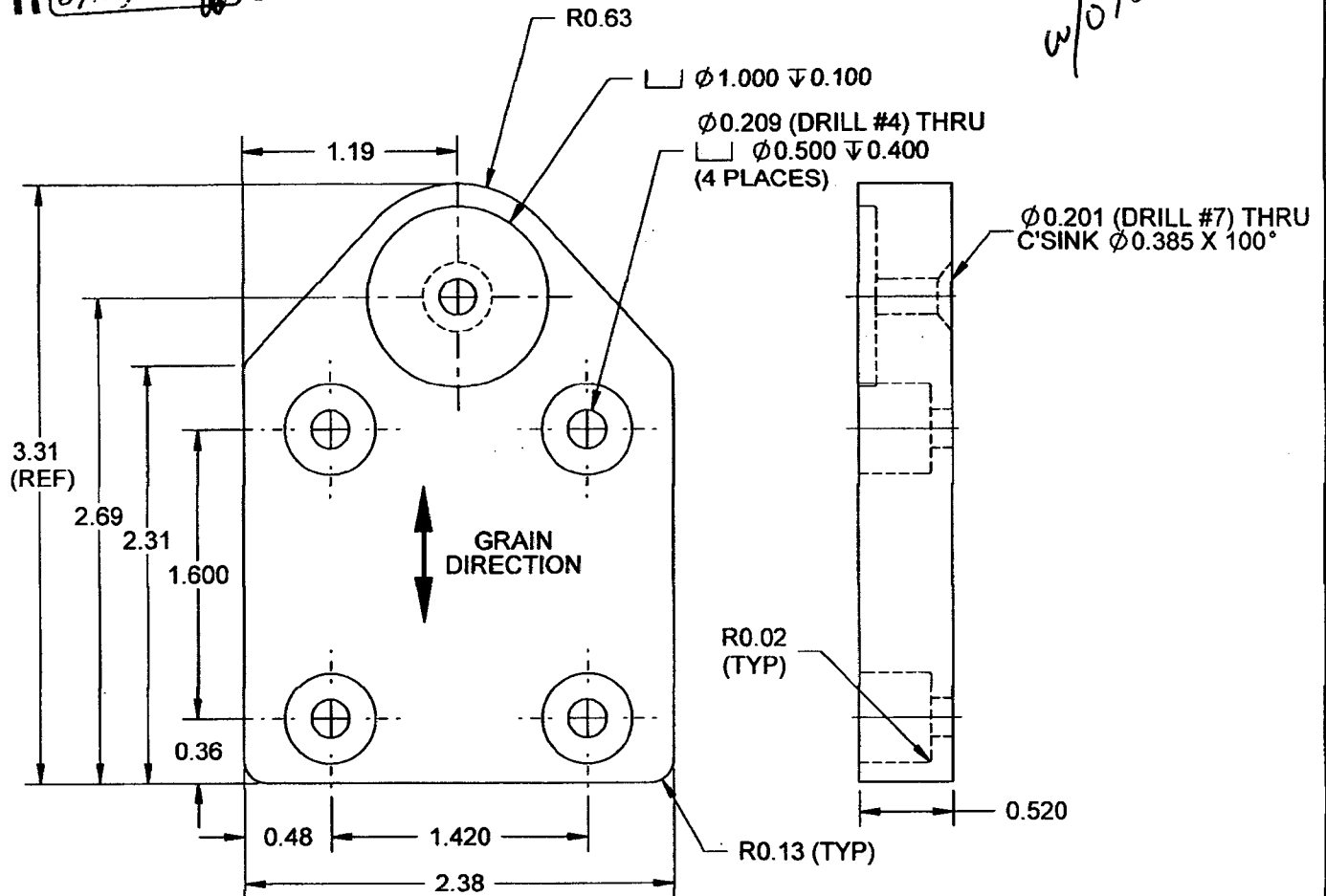
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.31	+/-0.030	3.312"	✓			
2.69	+/-0.030	2.690"	✓			
2.31	+/-0.030	2.310"	✓			
1.600	+/-0.010	1.599"	✓			
0.36	+/-0.030	0.358"	✓			
1.19	+/-0.030					
2.38	+/-0.030	2.380"	✓			
1.420	+/-0.010	1.421"	✓			
0.48	+/-0.030	0.479"	✓			
R0.63	+/-0.030	R0.630"	✓			
R0.13	+/-0.030	R0.130"	✓			
R0.02	+/-0.030	R0.020"	✓			
Ø0.209	+0.005/-0.001	Ø0.211"	✓			
Ø0.201	+0.005/-0.001	Ø0.203"	✓			
0.520	+/-0.010	0.521"	✓			
Ø0.500 x 0.400	+/-0.010	Ø0.502 x 0.400"	✓			
Ø1.000 x 0.100	+/-0.010	Ø1.004 x 0.101"	✓			

Measured by: J.F.	Audited by: J.F.	Prototype Approval:	N/A
Date: 09/02/23	Date: 09/02/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.04	New Issue	KJ/JLM	J.F.

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 1 OF 4
DATE 07.02.19	TITLE ADAPTER	SCALE 1:1	
REV A	DATE 07.02.19	DESCRIPTION NEW ISSUE	

RELEASED
07.03.22*w/045926***D3573-1 ADAPTER****NOTES:**

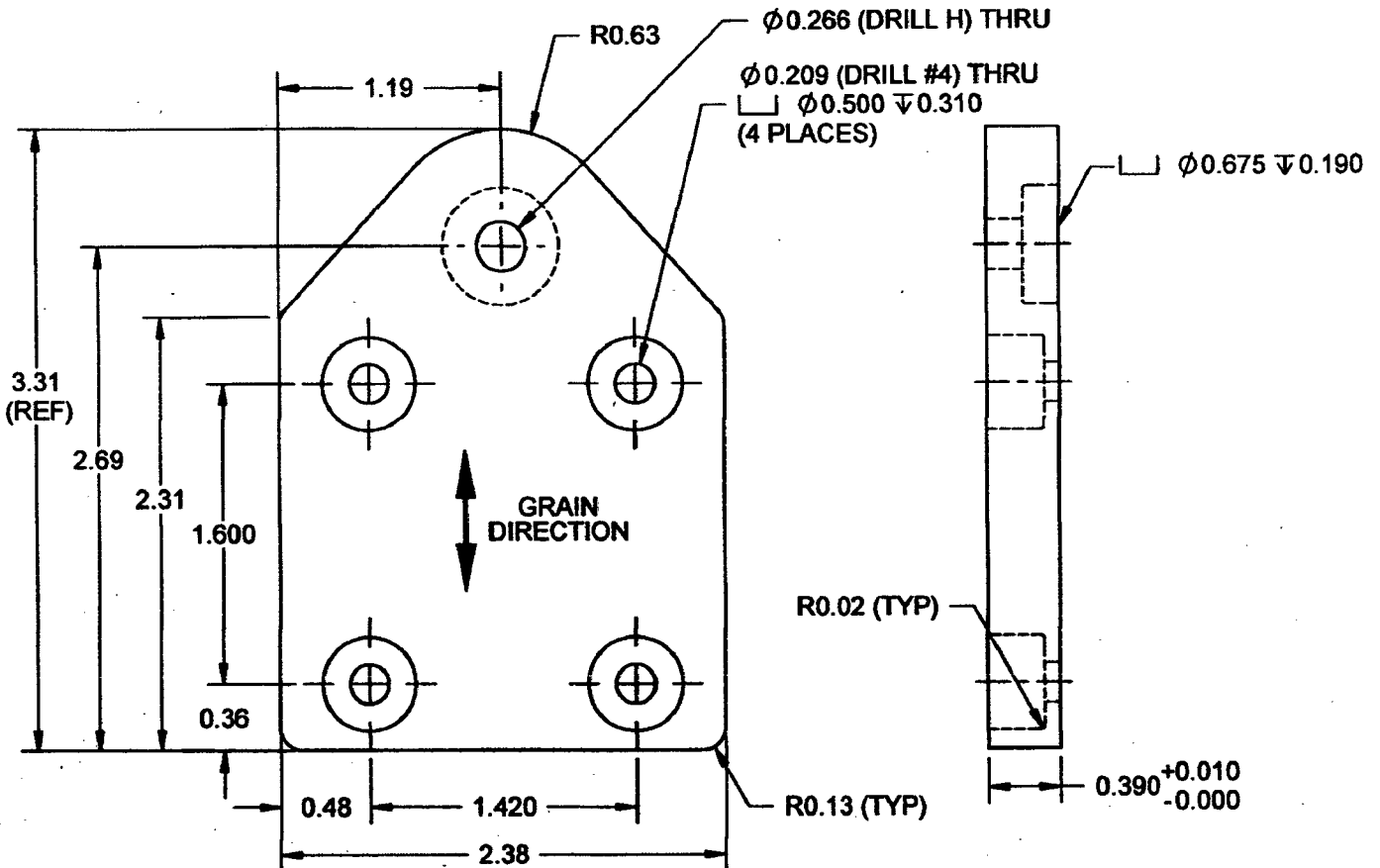
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

RELEASED
07.02.19**D3573-3 ADAPTER**

45926

NOTES:

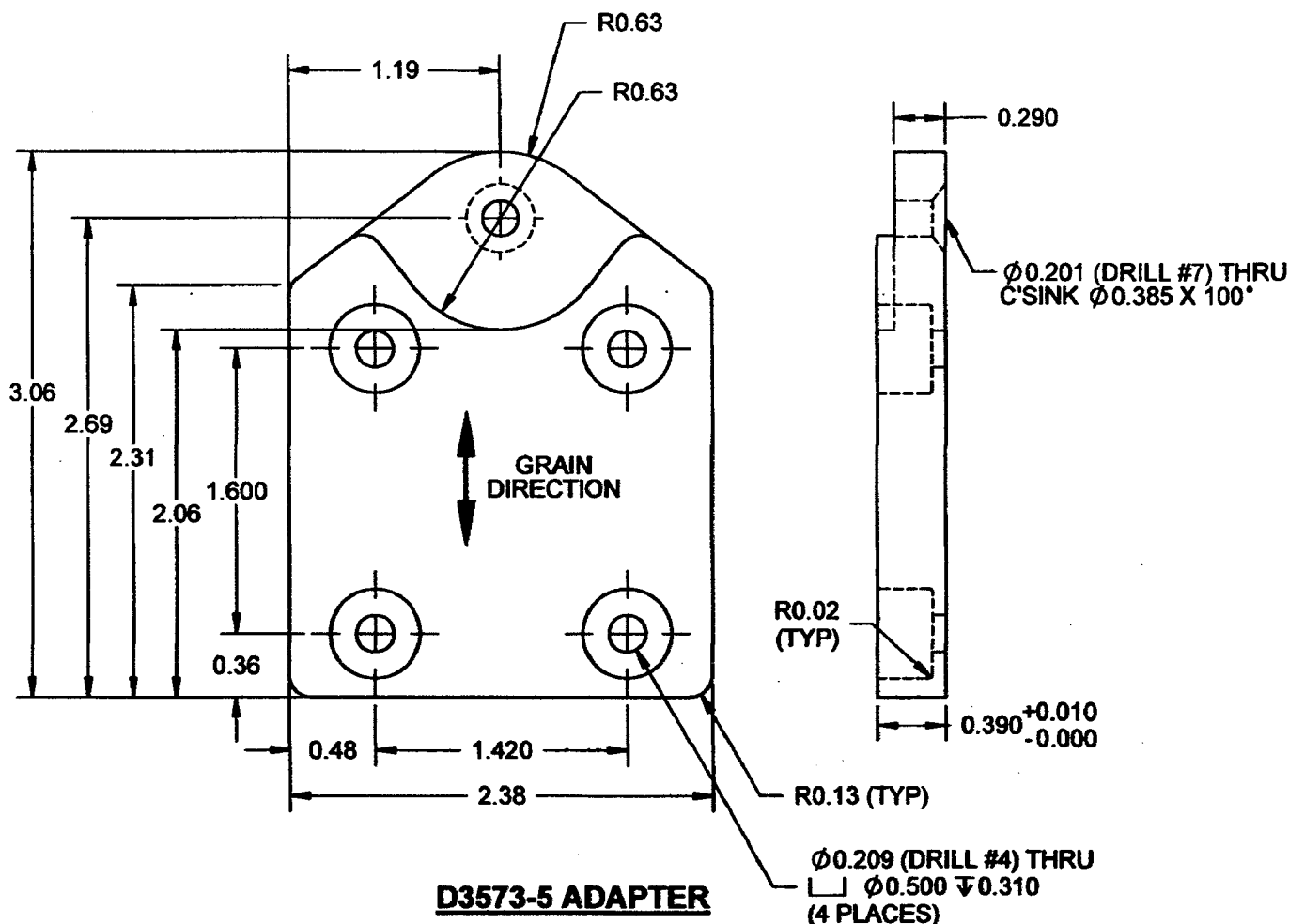
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
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- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER
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DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

RELEASED
07.04.02**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

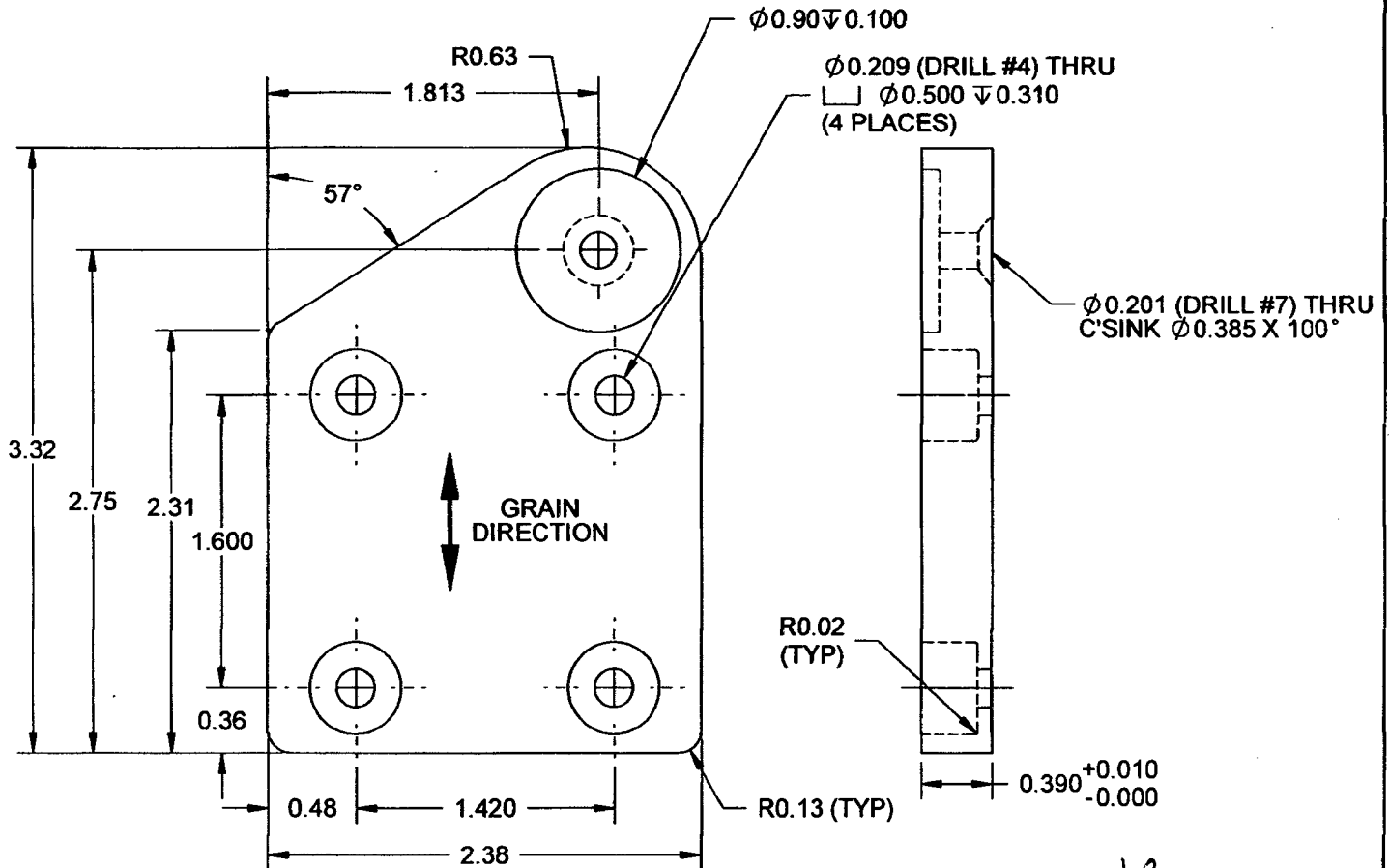
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1

RELEASED
07.04.02



D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
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POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
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